

Date: Wednesday, 04/02/2009 11:30:51 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 45491		
Estimate Number	: 10368		
P.O. Number	:	Part Number	: D30481
This Issue	: 04/02/2009 S.O. No. :	Drawing Number	: D3048 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 43703	Material	:
Written By	: <u>                    </u>	Due Date	: 11/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>                    </u>		
Comment	: Est: A 02.11.19 New issue KJ/RF Est Rev:B Now on Waterjet 06-10-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 3.6312 sf(s)/Unit Total : 7.2624 sf(s)  
 2024-T3 .063 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.063 thick  
 (M2024T3S.063) Batch: 110337 1B 9-2-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3048  
 Dwg Rev: A2  
 Prog Rev: A2

1B 9-2-4

2-Deburr if necessary 1B 9-2-4

②

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-2-4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/02/04 ②

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form on CNC Brake per Dwg D3048

509/02/12 ②

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 04/02/2009 11:30:51 AM  
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Drawing Name: DOUBLER

Job Number: 45491

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Handwritten initials*

*09-02-12*

*(X2)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 09/02/12*

*(X2)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten signature*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/02/17*

Job Completion



*mf 09-02-13*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

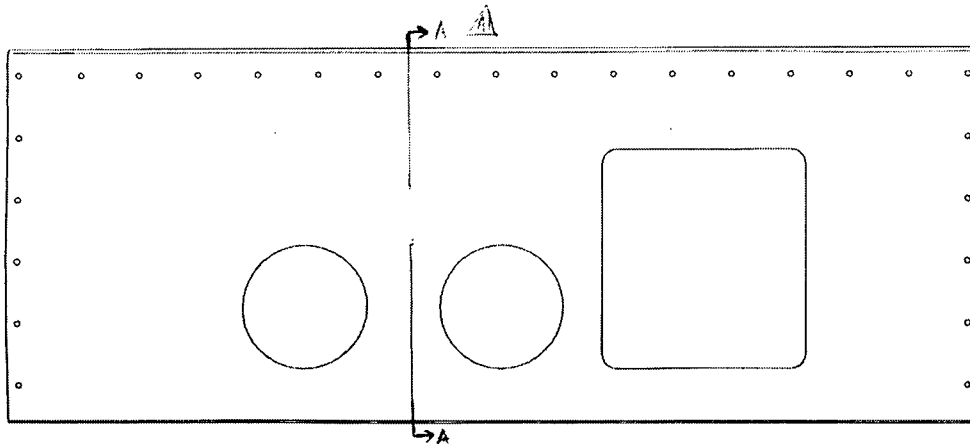
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

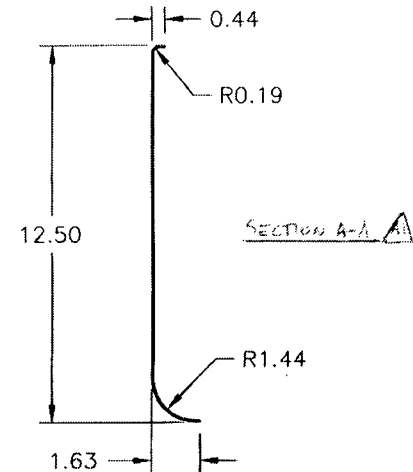
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

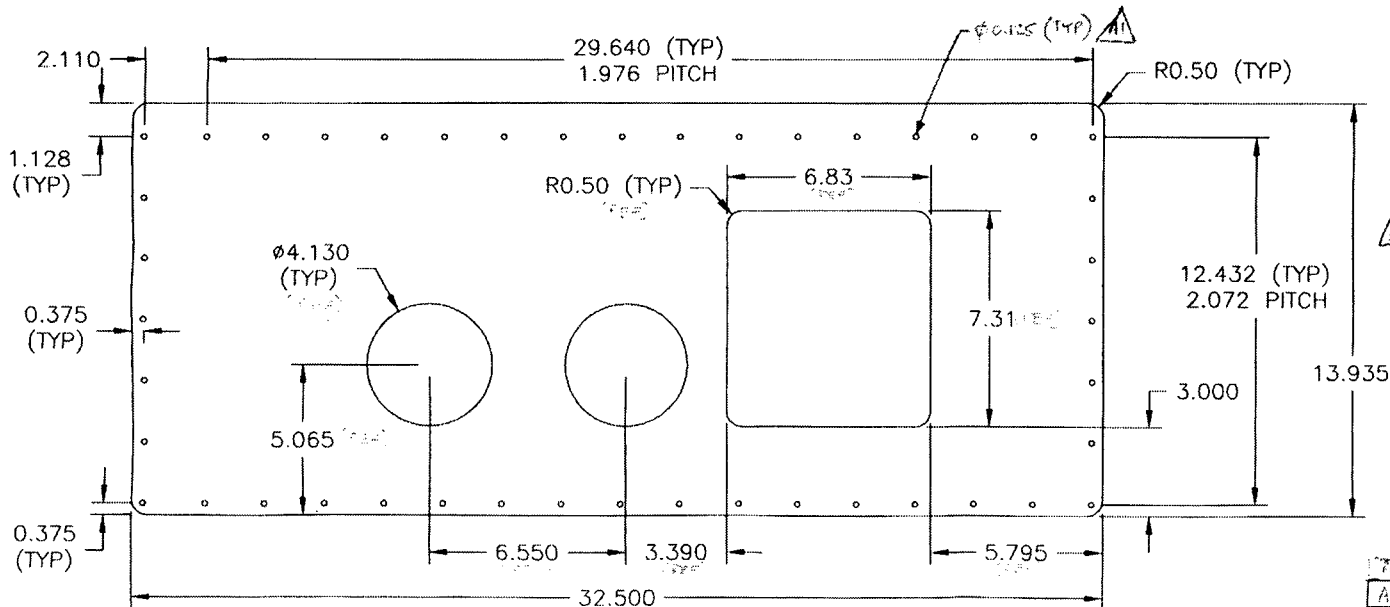




D3048-1



SECTION A-A



D3048-1 FLAT PATTERN

MATERIAL: 2024-T3 (QQ-A-250/4)  
0.063 THICK  
FINISH: ACID ETCH, ALODINE PER DART  
QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE NOTED

45491



AI	02 11 20	Correct Date Errors
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY RT	<b>DART</b> DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3048
DATE	01.09.25	TITLE DOUBLER
		REV. A SHEET 1 OF 1 SCALE 1:4

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W10:45491  
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